Jan: 30

Work Orde				*77.	354*								Page 1
Item ID: Revision ID:	D350-591-3	11	1	Accept	*N9	ററ	040	100	)*	Setup	Start	*N	S1*
Item Name:	Heli-Access-S	Step, Long LH									Stop	*N	S2*
Start Date: Required Date: Reference:	06/12/2011 30/01/2012	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*			Item l omer:	ID:						
Approvals:	Process Pla	in: M.L.J	Date: 1117 06	Tooling:	,		ate:	_	]	Run	Start	*N	R1*
			Date:	SPC (Y/N):			ate:				Stop	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Too	l ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr											,
. D3272	Rev	В		·			_						
*1 \\n^* \\ DC \\ Document Control		DOCUMENT CONTRO  Memo  Photocopy 1	L bluefile and type labels as pe	0.00 0.00 or PPP D350-591-311	CHG001	rla	06		H	<u>} d</u>	<u>o(</u> 1	MLJ	12-2-1
110 *110*		Large Fab		0.00		12.	V D:0-2	5	10		Ø		
Large Fab Large Fab		Memo 1-Bevel end	for welding FWD ONLY	0.00						l			
		2-Weld Supp D3272 A/RAluminu 3-Grind End	1197/2	Fwd End Plate as per (	QSI 004 & Dwg	27							

Dart	<b>Aeros</b>	pace	Ltd
------	--------------	------	-----

		— - <del></del>								
W/O:			W	ORK ORDER CHA	NGES					* _
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							·			
							arans.	-		
				,				:		
Part No	:	PAR #:	Fault Cate	gory:	NCR	: Yes N	lo <b>DQ</b>	\:	Date:	
		esolution:								
NCR:			WORK ORD	ER NON-CONFOR	MANCE	(NCR)				
DATE	STEP	Description of NC Section A	Initial	Corrective Action Action Description	Section B	Sign &	Verific Section		Approval Chief Eng	Approval QC Inspector
		Section A	Chief Eng	Chief Eng		Date	Secu	on C	Criler Eng	QC Inspector
				<u></u>						

Work Order ID 77354 \*77354\* Page 2 December-06-11 10:27:43 AM \*N900040100\* D350-591-311 Accept Item ID: Setup Start **Revision ID:** Stop Heli-Access-Step, Long LH Item Name: \*10\* Start Qty: 10.00 **Start Date:** 06/12/2011 **Cust Item ID: Required Date:** 30/01/2012 Req'd Qty: 10.00 \*10\* **Customer:** Reference: Run Process Plan: \_\_\_\_\_ Date: **Tooling:** Date: Approvals: QC: Date: SPC (Y/N): Date: Sequence ID/ Tool ID Tool # Plan **Operation** Accept Reject Reject Set Up/ Insp. **Work Center ID Description** Code Qty Oty Number Stamp **Run Hours** QC9- Inspect visual per QSI004- Fusion Welds 0.00 120 M 12.01.270 \*120\* 0.00 QC Memo Quality Control QC5- Inspect part completeness to step on W/O 130 \*130\* 0.00 8 12/01/27 QC Memo Quality Control 140 Chemical Conversion Coat per OSI005 4.1 0.00

0.00

Memo

\*140\*

Hand Finishing

HandFinish

Le 12.01.27

-41170	oopaoo								
W/O:			WO	RK ORDER CHANG	ES	, .			•
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	·								
Part No.		PAR #·	Fault Cated	lorv.	NCR: Yes	No DO	Δ.	Date:	
r urr ito		solution:							
NCR:	R:		WORK ORDE	R NON-CONFORMA	NCE (NCF	₹)			
		Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	k Secti	on C	Chief Eng	QC Inspector
1									

Work Order ID 77354 \*77354\* Page 3 December-06-11 10:27:43 AM Item ID: D350-591-311 Accept \*N900040100\* Setup Start **Revision ID:** Stop Heli-Access-Step, Long LH Item Name: \*10\* 06/12/2011 **Start Date: Start Qty: 10.00 Cust Item ID: Required Date:** 30/01/2012 Req'd Qty: 10.00 \*10\* **Customer:** Reference: Run Start Process Plan: Date: Tooling: Date: **Approvals:** Stop SPC (Y/N): Date: Date: Tool ID Tool # Plan Sequence ID/ Operation Set Up/ Accept Reject Reject Insp. **Work Center ID** Description Code **Qty Qty** Number Stamp **Run Hours** QC3- Inspect Part Finish 0.00 150 \*150\* 0.00 Memo Quality Control 180 0.00 Large Fab \*180\* Large Fab 0.00 Memo 1-Assemble Leg Assembly as per Dwg D3272. Le 12/01/28 Large Fab 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 Il 12.01.31 10 f

6-Grind End Plate flush

7-Install last rivet as per Dwg.

A/RAluminum Rod\_j/45/4

5-Weld Aft End Plate as per QSI 004 & Dwg D3272

	•								
W/O:		**************************************	W	ORK ORDER CHANG	ES				3
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cat	egory:	_ NCR: Ye	s No DQ	A:	Date:	
	Re	esolution:	Dispositi	on:	_ QA: N/C	Closed:		Date:	
NCR:			WORK ORE	ER NON-CONFORMA	ANCE (NO	R)			
DATE	STEP	Description of NC Section A	Corrective Action  Initial Action Description Chief Eng Chief Eng		on B	1&   Sect	cation tion °C	Approval Chief Eng	Approval QC Inspector
			Office Eng	Office Eng					
		·							
	!								
		<u> </u>					-		. "

	Work Order ID 77354  December-06-11 10:27:43 AM			*77:	354*		_					Page 4
Item ID: Revision ID: Item Name:	D350-591-3 Heli-Access-S			Accept	*N900	040	100	ገ*	Setup	Start Stop	IVI	S1* S2*
Start Date: Required Date: Reference:	06/12/2011	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item l Customer:	ID:					IV	. 12
Approvals:		an:		Tooling: SPC (Y/N):		ate:			Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center II 190 *100*	)	Operation Description QC10- Inspect visual per	QSI004- ground welds	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Rej Qty	•	Reject Number	Insp. Stamp
QC Quality Control		Мето		0.00 8 (7)	10(13)							
200		QC5- Inspect part comple	eteness to step on W/O	0.00								
*200* QC Quality Control		Memo		0.00	21413,			44	) —			
210		Chemical Conversion Co	at per QSI005 4.1	0.00				1,227	- <b>/</b>	M	1/,	o la la
*210* HandFinish Hand Finishing		Memo		0.00				lox.	( <b>J</b> )—	<u> </u>		<u> </u>

-u	oopaoc								
W/O:			W	ORK ORDER CHANG	ES				*
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cat	egory:	_ NCR: Ye	s No D	QA:	Date: _	
	Re	esolution:	Dispositi	on:	_ QA: N/C	Closed: _		Date: _	·
NCR:			WORK ORE	DER NON-CONFORM	ANCE (NO	CR)			
DATE	STEP	Description of NC			ion B	Ver	ification	Approval	Approval
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Section C			QC Inspector
		·							

Work Orde				*77.	354*					Page 5
Item ID: Revision ID: Item Name:	D350-591-3 Heli-Access-S	11 Step, Long LH		Accept	*N900	040	100	* Set	up Start Stop	ומיטו
Start Date: Required Date: Reference:	06/12/2011	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item I Customer:	ID:				14( )/
Approvals:		an:	Date:	Tooling: _ SPC (Y/N):		ate:		Ru	n Start Stop	"NRT"
Sequence ID/ Work Center II 220 **20* Powdercoat Powder Coating  230 **230* HandFinish Hand Finishing	(	Operation Description White Gloss(Ref:4.3.5.1)  Memo START TIM OVEN TEM FINISH TIM Wing Walk as per dwg Q Memo	1745 E:3 E:275	Set Up/ Run Hours 0.00 0.00 0.00 0.00 0.00	Tool ID	Tool #	Code /	-	Qty  / //	Reject Insp. Number Stamp
240 * <b>740</b> * QC Quality Control		QC3- Inspect Part Finish  Memo		0.00		૮૭૫ હ	- Tebam	1 DLKI 18 ASU RE	•	Il 12/62/62

W/O:			WC	RK ORDER CHANG	GES			· · · · · · · · · · · · · · · · · · ·		*	
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
				•							
		<del></del>		<del></del>							
Part No	:	PAR #:	Fault Cate	jory:	NCF	R: Yes	No <b>DQ</b>	A:	Date:		
	Re	esolution:	n:	QA:	N/C CI	osed:	: Date:				
NCR:			WORK ORDE	R NON-CONFORM	ANCE	(NCR	)				
DATE	STEP	Description of NC		Corrective Action Section B			Verific	ation	Approval	Approval	
DATE	SIEP	Section A	Initial Chief Eng	Action Description  Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector	
•											
								- 2			

Work Orde				*773	54*							Page 6
Item ID: Revision ID:	D350-591-3	11		Accept	*N900	040	100	)* s	Setup Sta	art *	N:	S1*
Item Name:	Heli-Access-S	Step, Long LH							St	op 🛪	N.	S2*
Start Date: Required Date: Reference:	06/12/2011 30/01/2012	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item I Customer:	ID:						
Approvals:	Process Pla	ın:	Date:	Tooling:	D:	ate:	·-	F			NI	<b>२1</b> *
			Date:	SPC (Y/N):	D:	ate:			Sto	<sup>эр</sup> *	NI	₹2*
Sequence ID/ Work Center II	<b>D</b>	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reje Num		Insp. Stamp
250		Pick Kit		0.00							_	_
*250* Packaging Packaging	,	Memo		0.00					10	) <u>-</u> C	) <i>)</i>	-02
260		QC4- 100% Inspect kits f	for completeness	0.00								
*26 <b>0</b> *				0.00 512/62	06		(	(4D)	·			
QC Quality Control		Мето		0.00			(	H				
270				0.00						/		)
*270*		Packaging						(	12/2/1	ラ	1/0	
Packaging		Memo		0.00					///			

Identify and pack for shipping as per PPPD350-591-311 Location:

Packaging

W/O:			W	ORK ORDER CHANG	ES					` '		
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
									,			
·										,		
Part No	•	PAR #:	Fault Cate	egory:	_ NCR	: Yes I	No DQ	A:	_ Date: _			
	Re	esolution:							Date:			
NCR:		•	WORK ORDER NON-COM				· · · · · · · · · · · · · · · · · · ·					
DATE	STEP	Description of NC	1		ion B	Cian 0	Verific		Approval	Approval		
DAIL	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector		
									·			

	Work Order ID 77354  December-06-11 10:27:44 AM			*77.	354*							Page 7
Item ID: Revision ID: Item Name:	D350-591-3	11 Step, Long LH		Accept	*N900	<b>04</b> 0	100	)*	Setup	Start Stop	i VI	S1* S2*
Start Date: Required Date Reference:	06/12/2011	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item I Customer:	D:					I VI	
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	1/7	R1* R2*
Sequence ID/ Work Center I 280 *280* QC Quality Control	D	Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accep Qty	ot Re Qt	•	Reject Number 2 8	Insp. Stamp

MB 12-02-07

W/O:			WO	RK ORDER CHANGE	ES				,
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
-									
Part No	-	PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	A:	_ Date: _	
	Res	solution:	Disposition	):	QA: N/C Cld	sed:		Date: _	·
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR	)		77.4100	
		Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
								157,5	

#### **Picklist Print**

December-06-11 10:27:47 AM

Work Order ID: 77354

\*77354\*

D350-591-311 Parent Item:

\*D350-591-311\*

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 06/12/2011

**Required Date:** 30/01/2012

Page 1

**Start Qty: 10.00** 

Required Qty: 10.00

**Comments:** 

IPP Rev:A04.03.22New issue KJ/RF

IPP Rev:B 07-06-09 Added D3272-1 JLM

IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1		Manufactured	No	B7765	3 710	110	Each	20.0000	1	10	1 >		
*D3272-1*									**	1/2	12.0	1.03	_(/
				Location	ı	Loc	<u>Oty</u>	Loc Code					
				WA			20				-		
					76038		10				_		
					76039		10				_		
3067-1		Manufactured	No			110	Each	125.0000	1	10	A		
*D3067-1*									**	-fl	12.0	1.25	
				Location		Loc 9	<u>Otv</u>	Loc Code					
				WA016	B78022		125			10			
				4	67582	<del></del> 1	2				=		
					68214		1						
					75468		32				-		
					76179		90						
3219-1		Manufactured	No			110	Each	106.0000	2	20	11		
*D3219-1*									**	-1	12.0	01.25	5
•				Location		Loc C	Oty	Loc Code		/			
				WA016 _	B78763		106			PA			
				_	73410		34			· ,			
					76226	<i>(</i>	72			6			

	. Johani								
W/O:			W	ORK ORDER CHANGE	ES				,
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		<u> </u>							
Part No		PAR #:	Fault Cat	egory:	NCR: Yes	No <b>DQ</b>	A:	Date: _	<del></del>
<i>.</i> *	^ R	esolution:	Dispositi	on:	QA: N/C	Closed:	· · · · · · · · · · · · · · · · · · ·	Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NC	R)		,	
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		on C	Chief Eng	QC Inspector
									·
	:								
		, ,							

December-06-11 10:27:47 AM

	*77	354*								
tep, Long LH			111*					-		
								Required Q	ity: 10.00	)
Manufactured	No		180	Each			20	•_		
						**	B77564	x(20)	Ao	12/01/28
		<b>Location</b>	<u>L</u>	oc Oty	Loc Code					
		WA015		148						
		75076		48						
		76180								
	No		180	Each			160			
W4*						**	B119883	(112)	Ao	12/01/28
		Location	L	oc Otv	Loc Code		B 120308	3 (48)		
			_							
		117364		253						
		117601		200						
Manufactured	No	116/12	180		33 0000	1	10			
Manufactured			700	240		44			1	4 100
						^ ^	<i>B</i> 79336	(XYD)	<u>Aa</u>	12/01/28
	<u>]</u>	<u>Location</u>	<u>L</u> e	oc Oty	Loc Code		B7879	7(x1)		
	,			33						
		66149		0						
		/6194		2						
	Purchased  **  Manufactured  Manufactured	tep, Long LH  Manufactured No  Purchased No  W4*  Manufactured No	Manufactured No  Location WA015 75076 76180  Purchased No  Location ST321 116188 117364 117601 117885 118840 119860 WA018 116712  Manufactured No  Location WA	*D350-591-311*  Manufactured No 180  Location WA015 75076 76180  Purchased No 180  ****  ****  **** ***  **** ***  **** *** ***  ****	*D350-591-311*  Manufactured No 180 Each    Location   WA015   148   75076   48   76180   100     Purchased No 180 Each   Each     V4*    Location   Loc Otv	*D350-591-311*  tep, Long LH  **D350-591-311*  State	*D350-591-311*  tep, Long LH  ****  Manufactured No 180 Each 148.0000 2  ***    Location   Loc Otv   Loc Code     WA015   148     75076   48     75076   48     75180   100     Purchased No 180 Each 2,362.000 16    W4**    Location   Loc Otv   Loc Code     WA015   180 Each 2,362.000   16    W4**    Location   Loc Otv   Loc Code     ST321   2357     116188   59     117364   253     117364   253     117364   253     117364   253     117601   200     117885   195     118840   1150     119860   500     WA018   5     118840   1150     119860   500     WA018   5     Manufactured No 180 Each 33.0000   1     ***    Location   Loc Otv   Loc Code     WA 33     66149   0     76193   31	*D350-591-311*  tep, Long LH  **D350-591-311*  Start Date: 06/12/2011  Start Qty: 10.00  Manufactured No 180 Each 148.000 2 20  *** 877564*  *** 877564*  *** 877564*  *** 81/988.3  Purchased No 180 Each 2,362.000 16 160  *** 81/988.3  *** 8	*** D350-591-311**  tep, Long LH  ***  ***  ***  ***  ***  ***  ***	*D350-591-311*  tep, Long LH  ***  ***  ***  ***  ***  ***  **  **

	Jopasi	2 2 1 4								
W/O:			WC	RK ORDER CHANG	ES					
DATE	STEP	PR	OCEDURE CHAI	NGE	B	/	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					<u> </u>		<del> </del>			
Part No	•	PAR #:	Fault Cate	jory:	l NCR: Y	es N	lo <b>DQ</b>	\:	Date:	
	R	esolution:	Disposition	);	QA: N/	C Clos	sed:		Date:	·
NCR:			WORK ORDE	R NON-CONFORM	ANCE (N	CR)				
D.4.T.E.	OTED	Description of NC			ion B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		gn & late	Section		Chief Eng	QC Inspector
		, \								
i e		1	1 1		1		1			

**Shop Packet Print** 

Page 3

December-06-11 10:27:48 AM

W/O:			W	ORK ORDER CHANGE	S	-	-*		1
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:							
	R	esolution:	Dispositio	n:	QA: N/C CI	osed:		Date:	
NCR:			WORK ORD	ER NON-CONFORMAI	NCE (NCF	R)		,	
DATE	STEP	Description of NC		Corrective Action Section			cation	Approval	Approval
	O.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti	on C	Chief Eng	QC Inspector
				÷					
	-								
				•					

			119641	2.50	75	150 0000	•	,-
D2618 *D2618*	Manufactured	No		250	Each	152.0000	**	
1 240		<u>L</u> c	ocation	Loc	e Oty	Loc Code		

ST019 152 52 74458 100 76130 D2230-3 Manufactured No 250 Each

Location Loc Qty Loc Code ST480 99 53881 70973 10 74440 75546 84

99.0000

Page 4

W/O:			WC	ORK ORDER CHANG	GES					1
DATE	STEP	PRO	OCEDURE CHA	NGE	E	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				,						
	•									
Part No		PAR #:	Fault Cate	gory:	NCR:	Yes N	lo DQ/	<b>\</b> :	Date:	
	R	esolution:	Disposition	n:	QA: N	/C Clo	sed:		Date:	·
NCR:			WORK ORDI	ER NON-CONFORM	IANCE (	NCR)	l			- And
DATE	CTED	Description of NC			ction B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Section		Chief Eng	QC Inspector
				19						

W/O:			WO	RK ORDER CHANG	BES				* * *
DATE	STEP	PR	OCEDURE CHAI	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
_			, , , , ,						
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A:	Date:	
	Reso	olution:	Disposition	:	_ QA: N/C C	losed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC			tion B		cation		Approval
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector
								:	
									:
		<del></del>							
		**************************************							

	Picklist Print December-06-11 10:27.	:48 AM								·		Page 6
	Work Order ID: 77354			*773	54*							
	Parent Item: D350-5 Parent Item Name: Hel	591-311 li-Access-Step, L	ong LH		n-591-3	311*			t <b>Date:</b> 0 rt <b>Qty:</b> 1	06/12/2011 0.00	Required Date: 30/0	
S	MS21042L5 *MS21042I	5*	Purchased	No		250	Each	2,192.000	2 * <b>*</b>	20 		
	MS21042L4	<i>1</i> *	Purchased	ST:	116105 116548 117611 1 <u>1817</u> 9 118910		Oty 692 5 43 52 496 96 1500 Each	Loc Code 10,136.00	_8 :*	20x		
) Al	<i>A</i> .	NAS1149D0363J	Purchased	STS STS	117441 117601 118451 516 119017	4	531 51 347 133 4605 4605 5000 Each	<u>Loc Code</u> 0.0000	4	50x	$\sim 4/\sim$	
O <sup>t</sup>	*AN960.ID1	10*						*	**	MI SP	12-02-02	

W/O:			W	ORK ORDER CHANGE	3				•
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		·				·			
									:
Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	<b>A</b> :	Date:	
	Re	esolution:	Disposition	on:	QA: N/C C	osed:		Date:	
NCR:			WORK ORD	ER NON-CONFORMAN	CE (NCF	R)			
DATE	STEP	Description of NC		Corrective Action Section		Verific		Approval	Approval
	0,2,	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section	on C	Chief Eng	QC Inspector
			,						
									. ,
							:		



				•
DESIG	p	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	•
CHECK		APPROVED	DRAWING NO.	REV., B
_	<u>e</u>	TA TA	D3272 SHEET	1 OF 3
DATE			TITLE	SCALE
07.0	5.18		STEP ASSEMBLY, HI LONG	NTS
Α		04.03.01	NEW ISSUE	
В		07.05.18	D3272-1 WAS D2622-120	

	QTY -041	QTY -042	PART NUMBER	DESCRIPTION
	X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
		Х	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
	1	1	D3065-041	LEG ASSEMBLY
	2	2	D3066-1	SPACER
i	2	2	D3067-1	END PLATE
	2	2	D3219-1	SUPPORT
7	1	1	D3272-1	STEP
	16	16	MS20600AD4W4	RIVET

#### **GENERAL NOTES:**

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY RETURN TO **ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER MUJ

11/12/06

Copyright © 2004 by DART AEROSPACE LTD

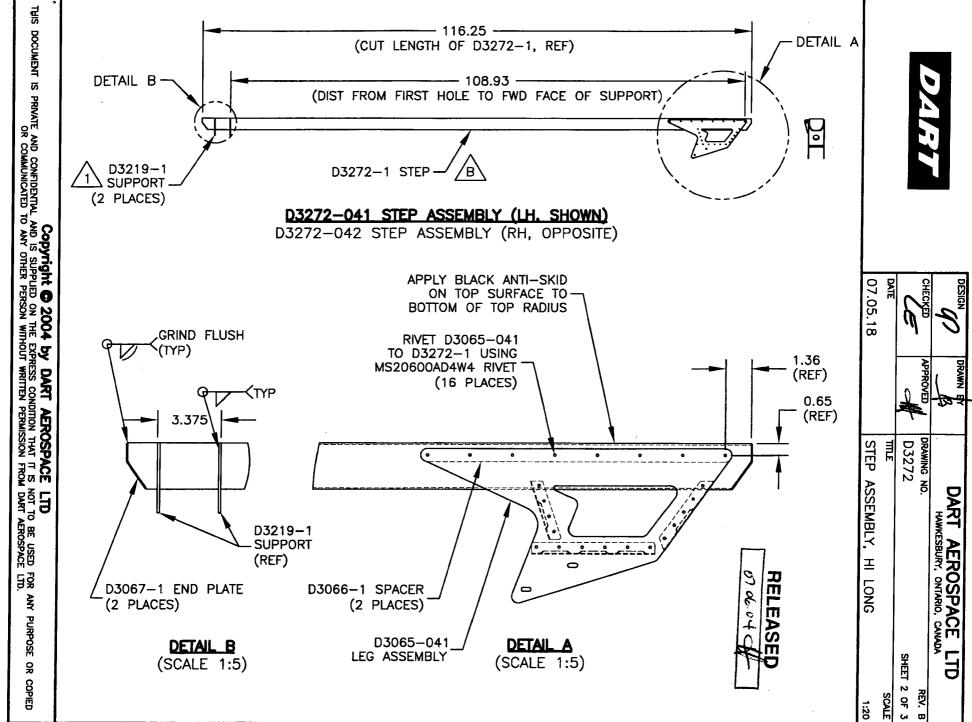
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Dart Aerospace Ltd	Dart	Aeros	pace	Ltd
--------------------	------	-------	------	-----

Dail Ac	ospace	Ltu							
W/O:			WC	RK ORDER CHANGI	ES				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								·	
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	
	Re	esolution:	Disposition	າ:	QA: N/C C	losed:		Date: _	
NCR:		,	WORK ORDE	ER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	on C	Chief Eng	QC Inspector

NOTE: Date & initial all entries

 <sup>₩:\</sup>fPORMS\Quality Assurance\approved QA\NCRWO RevE

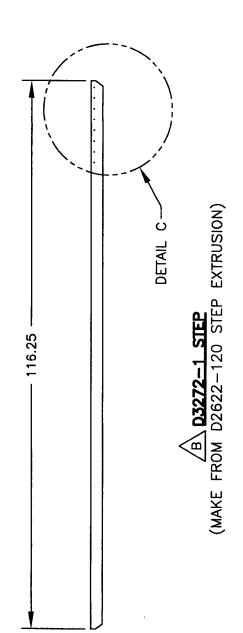


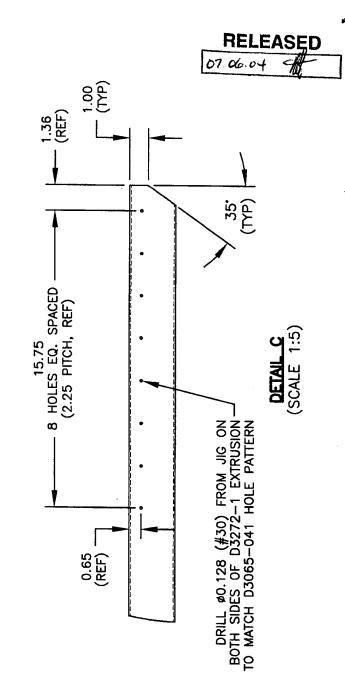
Dail Aci	Ospace	Liu							
W/O:		1.100mmin 1.100m	WC	RK ORDER CHANG	ES				*
DATE	STEP	PRO	CEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						<del></del>			
Part No	•	PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	A:	Date: _	
	Re	solution:						Date: _	
NCR:		V	WORK ORDE	ER NON-CONFORMA	NCE (NC	R)			
		Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Sect	on C	Chief Eng	QC Inspector
							<del></del>		



4324

DART AEROSPACE L HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. B D3272 SHEET 3 OF 3 DATE TITLE SCALE 07.05.18 STEP ASSEMBLY, HI LONG 1:20





Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Dart Aerospace Ltd	Dart	Aeros	pace	Ltd
--------------------	------	-------	------	-----

	Johann								
W/O:			V	VORK ORDER CHANGE	S				
DATE	STEP	PROC	CEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									1:5
Part No	:	PAR #:	Fault Ca	tegory:	NCR: Yes	No DQ	<b>\</b> :	Date: _	4,
	R	esolution:	_ Disposit	ion:	QA: N/C C	losed:		Date: _	
NCR:		W	ORK OR	DER NON-CONFORMAI	NCE (NCI	R)	,		
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Action Description	Sign			Approval Chief Eng	Approval QC Inspector
<del></del>		Cookienty	Chief Eng	Chief Eng	Date	)			
	15								
		. '							
									4

#### **REFERENCE ONLY**

#### DART AEROSPACE LTD.



D350-591 Page 23 of 23

Qty	Qtv	Qty	Qty	Qty	Qty	Qty	Qtv	Part Number	Description
-211	-212	-213	-214	-215	-216	-311	-312	T un riumber	Description
Х								D350-591-211	Heli-Access-Step™, Long Step - High Skid, LH
	Х							D350-591-212	Heli-Access-Step™, Long Step - High Skid, RH
		Х						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			Х					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				$\overline{\mathbf{x}}$				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
	**				Х			D350-591-216	Heli-Access-Step™, Short Step - Low Skid, RH
						Х		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
	,	1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	14	4	D2230-3	MOUNTING LUG
8	- 8							D2274	RADIUS BLOCK
						/ 2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030 -	CUSHION
2	2	1	1	1	1 /	2	2	D2856-400-720 . **	ABRASION STRIP
2	2				4.1		_	D3064-1	CLAMP
1	1	Ĺ						D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						o 1	1	D3278-041	SUPPORT ASSEMBLY
								ANICOFA	POLT
10	2 10	2	2	2	2	′ 2	2	AN3-35A	BOLT
10	10	2	2	2	2	<del>  </del>		AN4-11A	BOLT
		4	4	4	4 /	8	8	AN4-13A	BOLT
$\vdash$					4 .	2	2	AN5-36A -	BOLT
4	20	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	/ 16	16	AN960JD416	WASHER
<u> </u>	<del></del>	<del></del>				/ 4	4	AN960JD516	*WASHER
2	2	2	2	2	2 /	2	2	MS21042L3	NUT
10	10	6	6	6	6	/ 8	8	MS21042L4	NUT
<u> </u>		ļ	<u> </u>	ļ		7 2	2	MS21042L5	NUT
				L	l.	1	1	*DSI 9410-011	STEP MODIFICATION KIT

\*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore <u>NOT REQUIRED</u> to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.